

# Work Order ID 87131

**\*87131\***

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July-11-12 8:53:29 AM

Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/10/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: *7-07-12* Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr   |                      |         |        |              |               |               |                  |                |
| D2563                          | Rev C  |                      |         |        |              |               |               |                  |                |
| 100                            | Large Fab  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |  |                      |         |        |              |               |               |                  |                |
| Large Fab                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Large Fab                      | 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563                               |                      |         |        |              |               |               |                  |                |
|                                | 2-Debur ends   |                      |         |        |              |               |               |                  |                |
|                                | 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 |                      |         |        |              |               |               |                  |                |
|                                | 4- Grind   |                      |         |        |              |               |               |                  |                |
| 110                            | QC9- Inspect visual per QSI004- Fusion Welds                                   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

*[Signature]* 12.08.08 ①

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 87131

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Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/10/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description                                  | Set Up/<br>Run Hours        | Tool ID                    | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|-----------------------------|----------------------------|--------|--------------|---------------|---------------|------------------|----------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control        | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br>SMB<br>0.00 12-8-08 | (DAS<br>16<br>8-89 12/6/08 |        |              | 1             |               |                  |                |
| 130<br><b>*130*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo       | 0.00<br><br>0.00            |                            |        |              | 1             | 76            | 12-8-9           |                |
| 140<br><b>*140*</b><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo                      | 0.00<br><br>0.00            |                            |        |              | 1             | <del>1</del>  | 12-08-10         |                |

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 87131

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July-11-12 8:53:29 AM

Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/10/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID          | Tool #           | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                     |
|---|---|----------------------|------------------|------------------|--------------|---------------|---------------|------------------|------------------------------------|
| 150<br><b>*150*</b><br>Large Fab<br>Large Fab | Weld per dwg A/R Aluminum rod Batch: <u>120854</u><br>Large Fab<br><br>Memo<br><br>1-Inspect for foreign object per QSI 024<br><br>2-Weld Remaining End cap as per Dwg D2563 using DT 8343<br><br>3-Grind | 0.00<br><br>0.00     |                  |                  |              | 1             | 1             |                  | <u>12.08.10</u><br><u>12.08.10</u> |
| 160<br><b>*160*</b><br>QC<br>Quality Control  | QC10- Inspect visual per QSI004- ground welds<br><br>Memo   | 0.00<br><br>0.00     | DAS<br>16<br>8-8 | 12/06/13         |              |               |               |                  |                                    |
| 170<br><b>*170*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo   | 0.00<br><br>0.00     | 5mb<br>12.8.10   | DAS<br>16<br>8-8 | 12/06/13     | 1             |               |                  |                                    |

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 87131

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July-11-12 8:53:29 AM

Item ID: D2563      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 7/10/12      Start Qty: 1.00      **\*1\***      Cust Item ID:  
 Required Date: 8/10/12      Req'd Qty: 1.00      **\*1\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp  |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 175<br><b>*175*</b><br>HandFinish<br>Hand Finishing | Pressure Wash per QSI005 4.3<br><br>Memo<br>Touch up Alodine as per QSI005   | 0.00<br><br>0.00     |         |        |              | 1X            |               |                  | M-L<br>12/08/13 |
| 180<br><b>*180*</b><br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br><br>Memo<br>Touch up Alodine then<br>Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3<br><br>START TIME: 9:20<br>OVEN TEMPERATURE: 320°F<br>FINISH TIME: 9:50 | 0.00<br><br>0.00     |         |        |              | 1X            |               |                  | M-L<br>12/08/13 |
| 190<br><b>*190*</b><br>HandFinish<br>Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch M1122500.00<br><br>Memo  | 0.00                 |         |        |              | 1X            |               |                  | M-L<br>12/08/13 |

M121841

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Work Order ID 87131

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July-11-12 8:53:29 AM

Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Step Weldment Assembly  
Start Date: 7/10/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Start |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200                            | QC3- Inspect Part Finish                    | 0.00                 |         |        |              |               |               |                  |                |
| <b>*200*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 210                            | Identify as per dwg & Stock Location: _____ | 0.00                 |         |        |              |               |               |                  |                |
| <b>*210*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 220                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*220*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

1 2 12/08/14

B89430

12/8/30

MLJ 12/08/23

MLJ  
12-08-23

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

July-11-12 8:53:29 AM

Page 1

Work Order ID: 87131

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2244-116<br>Step Extrusion     |                        | Manufactured  | No          |                     |                  | 100             | Each               | 70.5000         | 1           | 1            |               | 8/12.08.08     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA                  |                  | 70.5            |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 80803               |                  | 70.5            |                    |                 | 1           |              |               |                |        |
| D2561<br>Lug                    |                        | Manufactured  | No          |                     |                  | 100             | Each               | 32.0000         | 2           | 2            |               | 8/12.08.08     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA                  |                  | 27              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 80813               |                  | 1               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 84326               |                  | 26              |                    |                 | 2           |              |               |                |        |
|                                 |                        |               |             | WA015               |                  | 5               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 66813               |                  | 5               |                    |                 |             |              |               |                |        |
| D2564<br>Mounting Angle         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 48.0000         | 2           | 2            |               | 8/12.08.08     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA                  |                  | 48              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 83429               |                  | 24              |                    |                 | 2           |              |               |                |        |
|                                 |                        |               |             | 83712               |                  | 4               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 85831               |                  | 20              |                    |                 |             |              |               |                |        |
| D2673-34<br>End Plate           |                        | Manufactured  | No          |                     |                  | 100             | Each               | 79.0000         | 1           | 1            |               | 8/12.08.08     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA                  |                  | 79              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 84535               |                  | 79              |                    |                 | 1           |              |               |                |        |
| D2673-34<br>End Plate           |                        | Manufactured  | No          |                     |                  | 150             | Each               | 79.0000         | 1           | 1            |               | 8/12.08.09     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA                  |                  | 79              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 84535               |                  | 79              |                    |                 | 1           |              |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

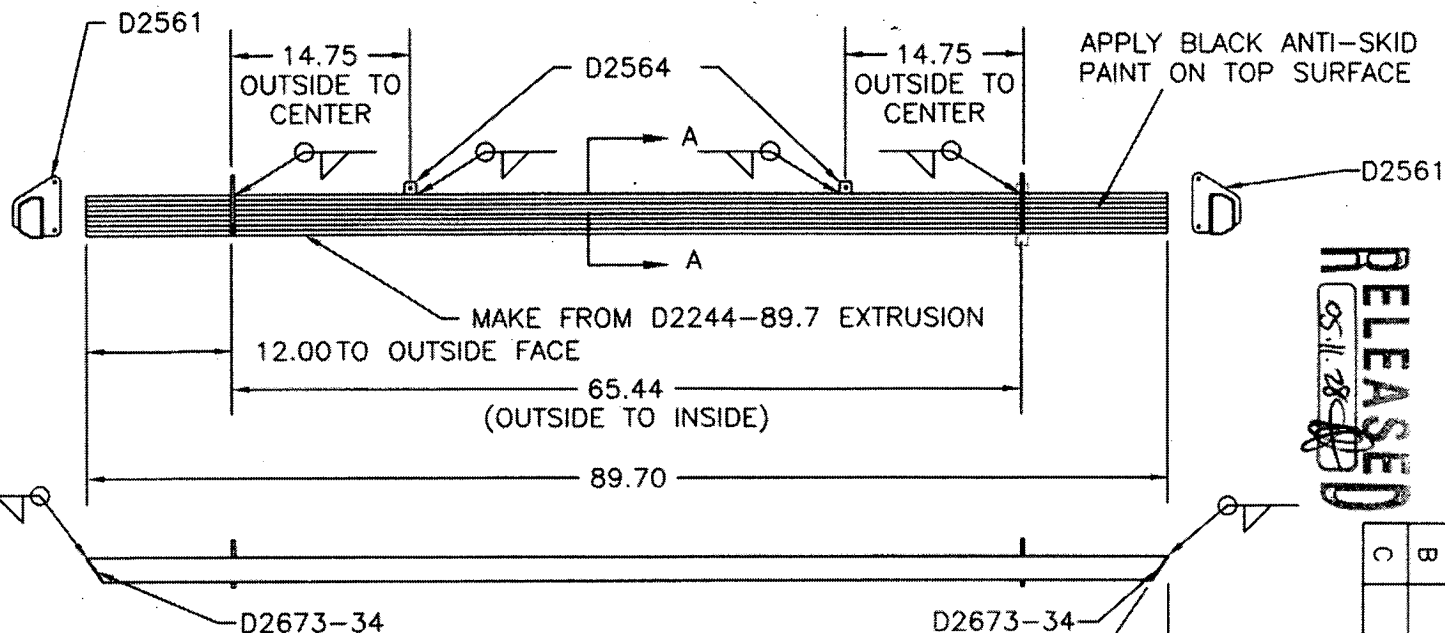
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



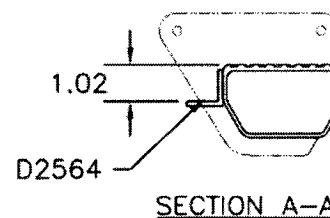
RELEASED  
05.11.28



#### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

| Part No.   | Description            | QTY |
|------------|------------------------|-----|
| D2563      | STEP WELDMENT ASSEMBLY | X   |
| D2244-89.7 | EXTRUSION*             | 1   |
| D2561      | LUG PLATE              | 2   |
| D2564      | MOUNTING ANGLE         | 2   |

\*cut per drawing



#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| DESIGN   | DRAWN BY               | DART AEROSPACE LTD           |
|----------|------------------------|------------------------------|
| BW       | PH                     | HAWKESBURY, ONTARIO, CANADA  |
| CHECKED  | APPROVED               | DRAWING NO.                  |
| PH       | PH                     | D2563                        |
| DATE     | TITLE                  | REV. C                       |
| 05.11.14 | STEP WELDMENT ASSEMBLY | SHEET 1 OF 1                 |
| A        | 96.04.26               | NEW ISSUE                    |
| B        | 97.05.14               | END CAPS CHANGED (WAS D2248) |
| C        | 05.11.14               | UPDATE NOTES                 |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                     |
|------|------|--------------------|----|------|-----|-------------------------------------|---------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | App<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                     |
|      |      |                    |    |      |     |                                     |                     |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries